ABSTRACT

This dynamic calibration qualifier relates to a tool monitor and assembly qualifier that verifies that the correct number of fasteners have been properly installed into an assembly. The device monitors an analog signature created by the tool and has the ability to dynamically calibrate itself while the tool is running. In the preferred embodiment, the stored variable is a clutch offset identified during a calibration phase. In a pulse tool, the programmed microprocessor is configured to identify and store the peak pressure of the first three pulses which are averaged together. The clutch offset is added to the average pulse value from which the clutch threshold is generated.